

Work Order ID 61880-2

**PRELIMINARY ISSUE**

Wednesday, September 08, 2010 3:26:58 PM

Page 1

Item ID: D4173-3

Accept

Revision ID: PRELIM

Item Name: Pod Radalt Doubler

Setup Start

Stop

Start Date: 9/8/2010 Start Qty: 3.00

Required Date: 9/13/2010 Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-9-08

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4173

PAT PA2

10.08.10

0.00

0.00

0.00

0.00

100



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg  
Dwg Rev: PAT  
Prog Rev: PAT

2-Deburr if necessary

Pat same dim. as Pat  
10.07.10

10-9-13

(4)

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

10-9-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Customer:

Approvals: Process Plan:  
QC:

Date:  
Date:

Tooling:  
SPC (Y/N):

Date:  
Date:

Run Start  
Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00 - inspection to part

Day only

0.00

Start 10/13

(24)

Memo

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

BR 10-9-14.

0.00

Memo

(4)

φ.

140



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3,5,6) per QSI005 4.3

0.00

M112588

0.00

2) JH

10/09/15

4

φ

Memo

Start Time: 2:45pm

Oven Temperature: 320°F

Finish Time: 3:45pm

W/O:		WORK ORDER CHANGES					
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Page 3

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Accept



Setup Start



Stop



Start Date: 9/8/2010 Start Qty: 3.00  
Required Date: 9/13/2010 Req'd Qty: 3.00



Cust Item ID:

Customer:



Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00 - inspected to AM

Memo

0.00

Done by  
8/10/04/16 (XCC)

160



Packaging

Packaging

Identify as per dwg & Stock Location: CA

0.00

Tan

Memo

0.00

BT 10-10-01 (3)

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/04 J

PR1010-01 (3)

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

PER RECEIVED DWG  
DATED 10.04.09

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, September 08, 2010 3:27:07 PM

Page 1

Work Order ID: 61880



Parent Item: D4173-3



Parent Item Name: Pod Radalt Doubler

Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.09.08 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

100

sf

104.9340

0.4935

1.558421



6061-T6 .063 Sheet

B10-9-13

Location

Loc Qty

Loc Code

MAT21

104.934

113608

104.934

113608

(4)

W/O:		WORK ORDER CHANGES					
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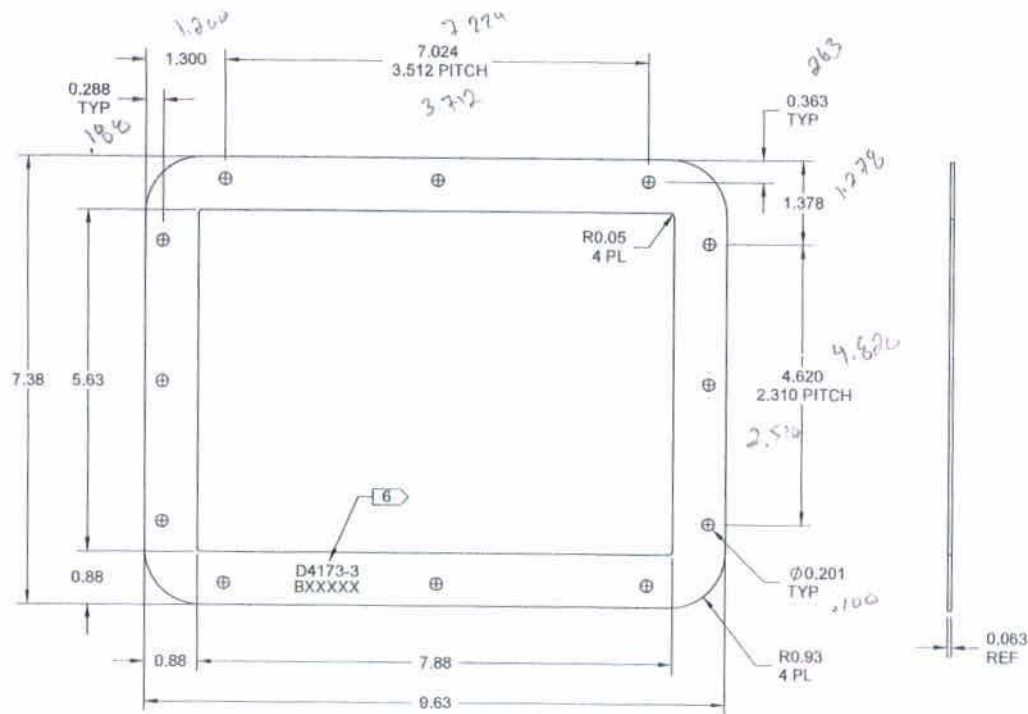
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**NOTE:** Date & initial all entries



Route / Bom / Arf

DONE



**D4173-3 POD RADALT DOUBLER**

**PRELIMINARY ISSUE**

10.09.08

**NOTES:**

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 010 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.16 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		<b>D4173</b>	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>POD RADALT MOUNTING PLATE</b>	NTS
DATE	10.09.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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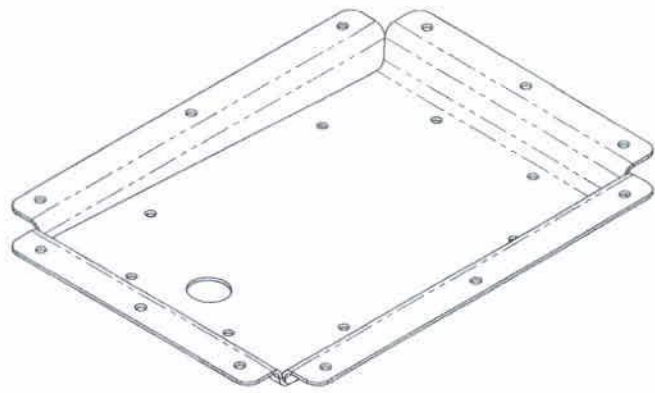
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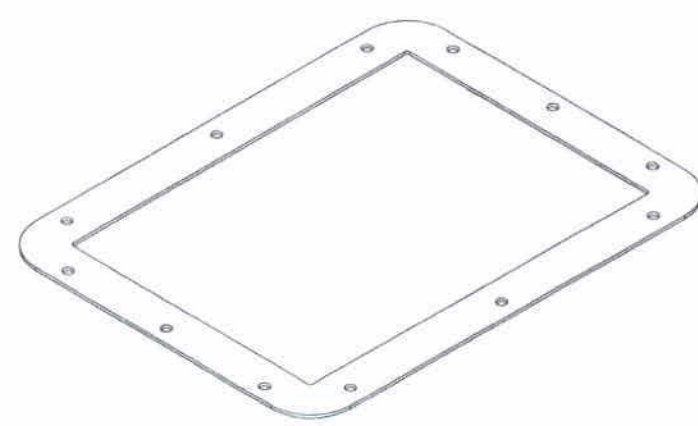
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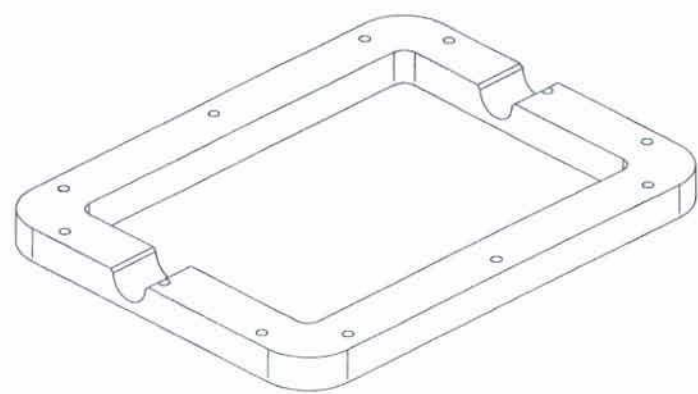




D4173-041 POD RADALT MOUNTING PLATE ASSY



D4173-3 POD RADALT DOUBLER



D4173-7 RADALT SCHIM

**PRELIMINARY ISSUE**  
10.09.15

PA2	REVISED GROOVE IN D4173-7: ADDED TOL ON D4173-7 THICKNESS	MB	10.09.15
PA1	NEW ISSUE	MB	10.09.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.01		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.	D4173	REV.	PA2
TITLE	POD RADALT MOUNTING PLATE ASSY	SCALE	NTS
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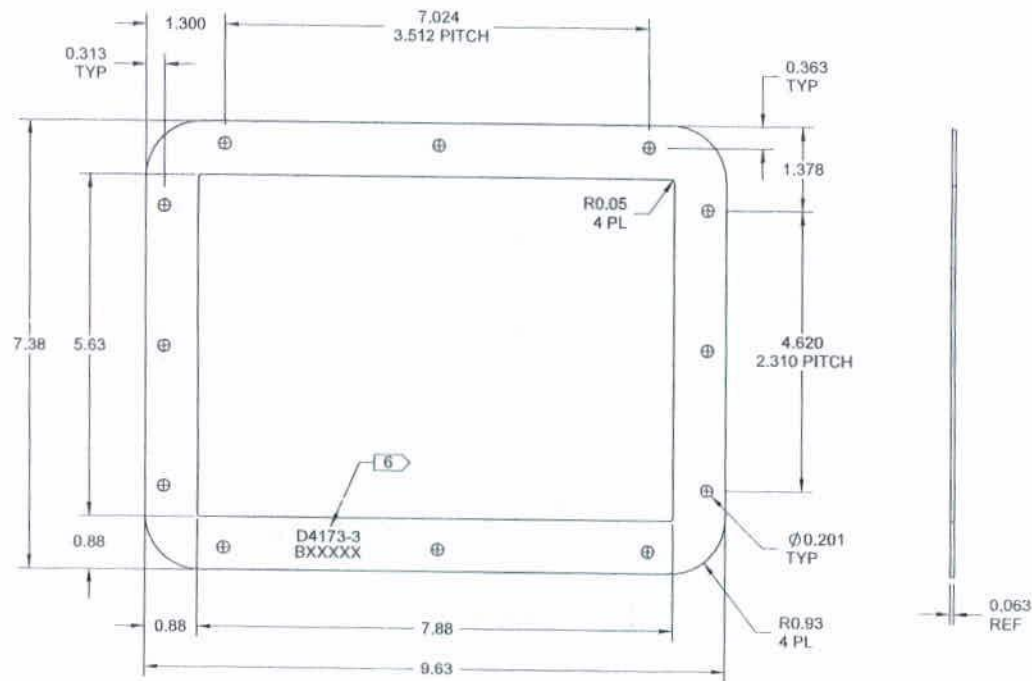
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10.09.15

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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.16 lbs

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		<b>D4173</b>	SHEET 5 OF 7
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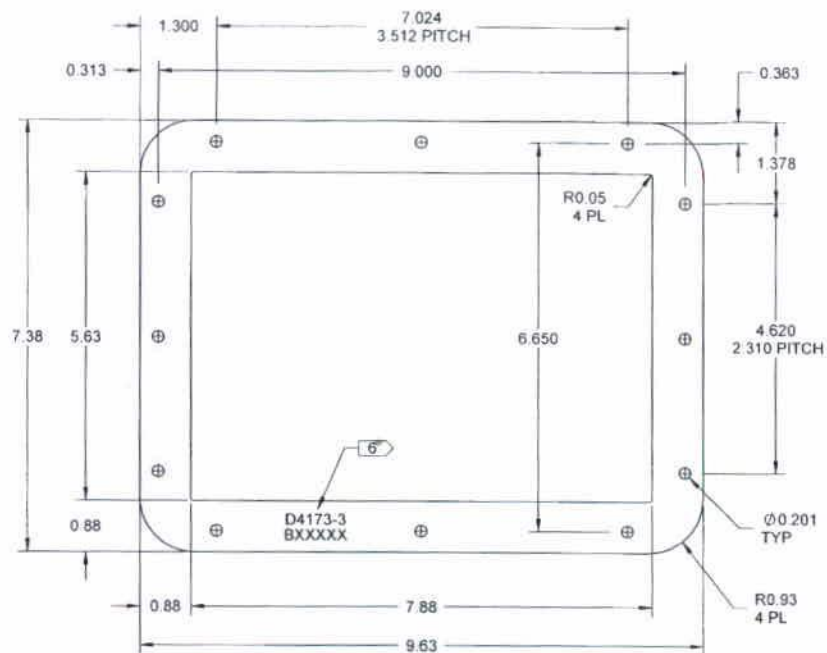
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MFG. APPR		<b>D4173</b>	SHEET 5 OF 8
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61880

**RELEASED**  
2010-09-29